

Date: Tuesday, 07/04/2009 10:18:19 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number :	46953		
Estimate Number :	10531		
P.O. Number :		Part Number :	D2572
This Issue :	07/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2572 REV E
First Issue :	//	Project Number :	N/A
Previous Run :	46433	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :	<u>JUD 09.04.07</u>	Due Date :	24/04/2009
Comment :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: 34874

mmf 09/04/11

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 46953 Double check by: *mmf*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

mmf 09/04/11 / J.L 09/04/14

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

mmf 09/04/11 / J.L 09/04/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:19 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 46953

Part Number: D2572

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

/SL 09/04/14

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/04/14 (10)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SP

09-04-14

(10)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M110 939

START TIME:

9:30

OVEN TEMPERATURE:

320°

FINISH TIME:

10:00

BR 09-04-15

(10)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

SP 09/04/15

(10)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

433

9/4/16

SP

(10)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



MF 09-04-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46953
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.438		
B	1.745	1.755		1.747	1.749	1.750	1.749		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.749	1.750	1.749		
E	7.990	8.010		8.001	8.000	8.001	8.000		
F	0.490	0.510		.504	.500	.500	.495		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.498	.500	.500		
J	1.174	1.184		1.179	1.175	1.175	1.179		
K	0.558	0.578		.567	.570	.570	.570		
L	1.174	1.184		1.174	1.175	1.175	1.180		
M	1.490	1.500		1.492	1.497	1.493	1.494		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	3.869	3.879		3.871	3.872	3.871	3.875		
P	0.115	0.135		.124	.124	.123	.124		
Q	0.115	0.135		.132	.135	.135	.130		
R	0.240	0.260		.250	.250	.249	.250		
S	0.115	0.135		.132	.136	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.956	2.957		
V	0.230	0.250		.237	.239	.236	.238		
W	0.115	0.135		.134	.131	.130	.128		
X	0.307	0.312		.311	.310	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.364	.363	.364		
AA	0.470	0.530		.500	.500	.500	.501		
AB	0.615	0.635		.623	.625	.623	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.389	1.391	1.390	1.391	1389	
AF	0.115	0.135		.130	.135	.135	.135		
AG	0.240	0.280		.260	.265	.263	.270		
AH	0.240	0.260		.241	.241	.245	.245		
AI	2.000	2.020		2.010	2.004	2.014	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: mmf
Date: 09/04/12

Audited by: 8/6
Date: 09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46953
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.439	.438	.440	.440		
B	1.745	1.755		1.747	1.747	1.750	1.750		
C	3.495	3.505		3.498	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.750	1.750		
E	7.990	8.010		8.000	8.003	7.999	7.997		
F	0.490	0.510		.498	.500	.503	.500		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.377	.376	.376		
I	0.490	0.510		.500	.500	.501	.502		
J	1.174	1.184		1.177	1.177	1.179	1.179		
K	0.558	0.578		.572	.573	.569	.570		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.494	1.494	1.495	1.495		
N	2.495	2.505		2.502	2.501	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.874	3.874		
P	0.115	0.135		.124	.123	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.249	.251		
S	0.115	0.135		.127	.128	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.956	2.955	2.960	2.960		
V	0.230	0.250		.239	.239	.241	.239		
W	0.115	0.135		.127	.130	.127	.128		
X	0.307	0.312		.311	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.364	.366	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.630	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.245	.246		
AE	1.375	1.395		1.391	1.388	1.370	1.390		
AF	0.115	0.135		.129	.130	.135	.135		
AG	0.240	0.280		.260	.270	.260	.260		
AH	0.240	0.260		.244	.245	.246	.248		
AI	2.000	2.020		2.004	2.005	2.005	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	/ J.L
Date:	09/04/14

Audited by:	SP
Date:	09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46953
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.996	7.996				
F	0.490	0.510		.501	.500				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.501	.503				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.570	.570				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.123	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.251				
S	0.115	0.135		.126	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.959	2.960				
V	0.230	0.250		.238	.242				
W	0.115	0.135		.127	.130				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.368				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.629	.630				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.247	.246				
AE	1.375	1.395		1.390	1.389				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.245	.247				
AI	2.000	2.020		2.006	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

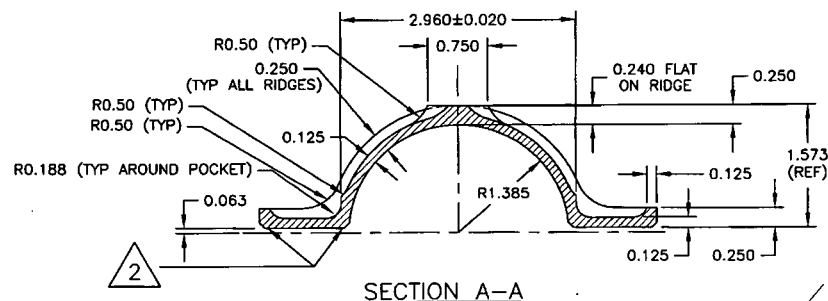
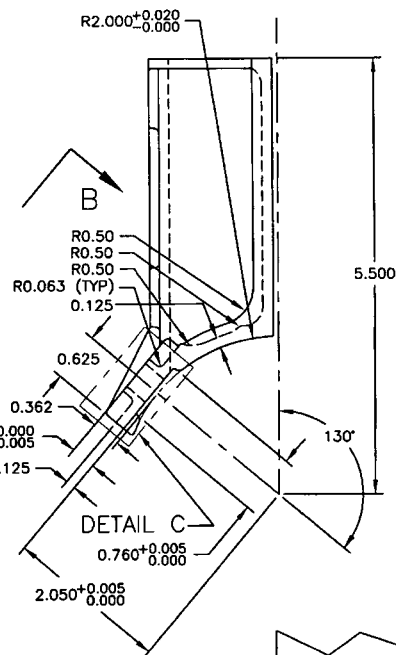
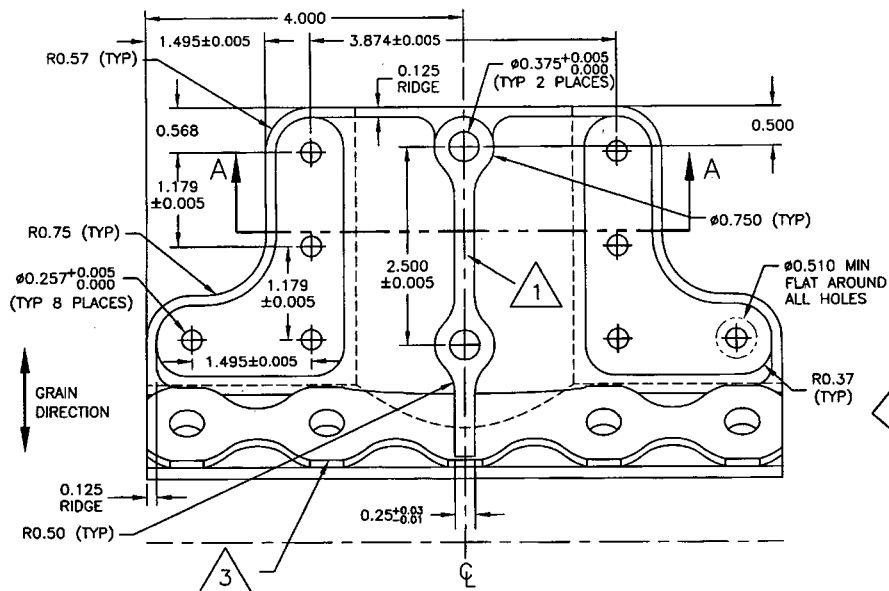
Measured by:	JL
Date:	09/04/14

Audited by:	88
Date:	09/04/14

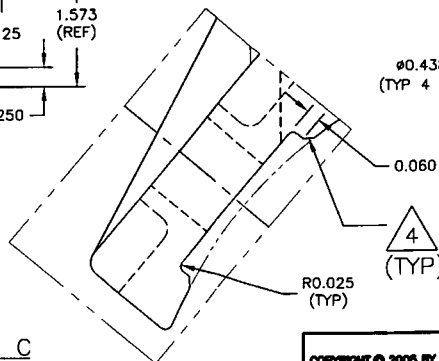
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A



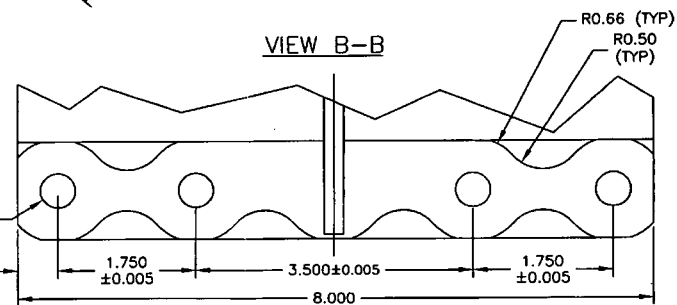
DETAIL C
SCALE 2:1

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE

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DART DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO. D2572
SHEET 1 OF 1
SCALE 2:3

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